



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400313-7
Job Sheet 173354



Part No: RBT400313-7

Job Qty: 1 ea

Part Name: Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400313 Rev 1 IPP Rev A 18.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Machining-3		
110	Lathe Conv	1 pcs		3/15/18	0.00	0.50	Lathe Conv-1		
120	QC	1 pcs		3/15/18	0.00	0.00	QC2 Machining-4		
130	Mill Conv	1 pcs		3/16/18	0.00	0.25	Mill Conv 1		
140	QC	1 pcs		3/16/18	0.00	0.00	QC2 Machining-4		
150	QC	1 pcs		3/16/18	0.00	0.00	QC8 Machining-4		
180	Outsource	1 pcs		3/16/18	0.00	0.00	Outsource12		
190	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging2		
200	QC	1 pcs		3/16/18	0.00	0.00	QC6		
210	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-1		
220	QC21-SA	1 Ea		3/16/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. 2-Deburr

Descriptions: 180 - -Issue P/O to Groupe Altech; PO 040059 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91247A740	Hex Head Screw	1 Ea (1 ea)	90-Start up Operation	5069440

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91247A740	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

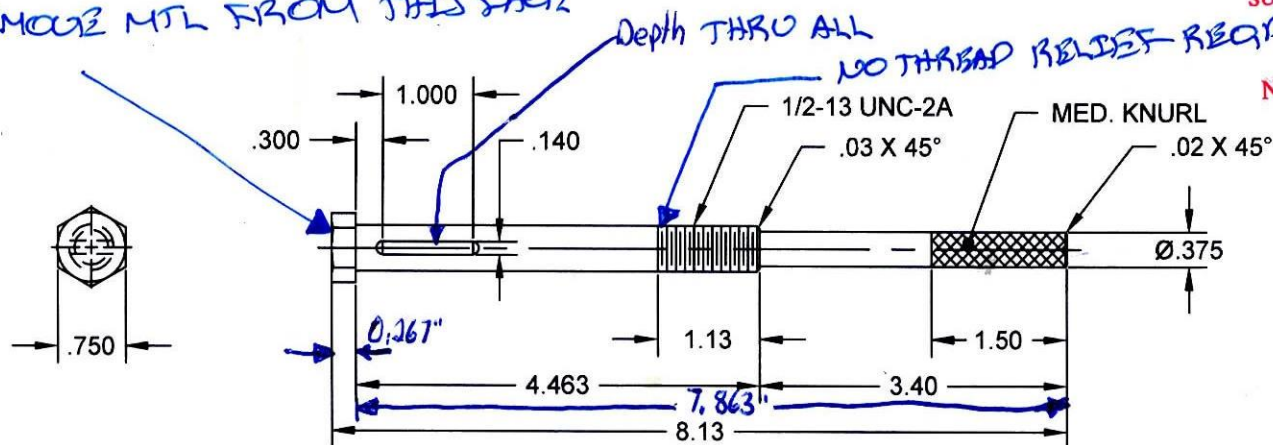
Work Order update only ☐

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This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED

Mfa 18/06/30
 REMOVE MTL FROM THIS FACE



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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

WORK ORDER
 NO. 173354 MLO
 18-02-28

— CENTER DRILL IS ACCEPTABLE

$X' - 0.567"$
 $X'' - 1.567"$

(-7)
 BOLT

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400313-7	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: CLOUGH
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	APPROVED <i>D Wed</i> HEAT TREAT FINISH BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL BELL 204, 205, 212
SCALE 1:2	DATE 1-7-11 SHEET 5 of 6

GA 068 23-1730-400 25-630-830 28-700-1000

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K8A 1K7 CANADA TEL: 613 692-5200 FAX: 613 692-5201 Email: sales@dartaero.com www.dartaero.com Date: 06/28/18 DART AEROSPACE Container No: S075026 Part: RBT400313-7 Job No: 173354 Serial No/Batch: S075026 Revision: 1 Inspector:																																																								
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040059**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040059
PO Date: 5/31/18
Due Date: 6/6/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173852	RBE350A93-3300-20	Tail Rotor Hub Socket -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs 12x	12 pcs	\$3.79/pcs	\$45.48
2	177469	RBE350A93-3400-00-1	Guide -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs 12x	12 pcs	\$3.20/pcs	\$38.40
3	173354	RBT400313-7	Bolt -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	7 pcs	0 pcs 7x	7 pcs	\$1.75/pcs	\$12.25
4	176875	C2-3-3	Latch Roller -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required	Firmed	6/5/18	19 pcs 18x	0 pcs 18x	19 pcs	\$10.4347/pcs	\$198.26

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(009916-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009916- 3

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-Jun-2018		Jessie Boisvert		040059				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3300-20 Rev.	RBE350A93-3300-20 01 -OXIDE BLACK [OXIDE BLACK] CLASS1 MIL-C-13924C	OXIDE-BLACK CH	12	12	0	0	0
2	RBE350A93-3400-00-1 Rev.	RBE350A93-3400-00-1 01 -OXIDE BLACK [OXIDE BLACK] CLASS1 MIL-C-13924C	OXIDE-BLACK CH	12	12	0	0	0
3	RBT400313-7 Rev.	RBT400313-7 01 -OXIDE BLACK [OXIDE BLACK] CLASS1 MIL-C-13924C	BLACK-OXIDE CH	7	7	0	0	0
9	3307-00-03 Rev.	3307-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924 CLASS 1	BLACK-OXIDE CH	30	30	0	0	0
10	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 01 -BLACK OXIDE ON SST MIL-DTL-13924D BLACK OXIDE FINISH, MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	30	30	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.